

Work Order ID 58857-2

May 19, 2010 10:28:49 AM

TODAY 11  
ord



Page 1

Item ID: D3953-17

Revision ID:

Item Name: Gas Spring Spacer

Start Date: 5/19/10

Start Qty: 18.00

Required Date: 5/26/10

Req'd Qty: 18.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3953

Dwg Rev: C

Prog Rev: C

2-Drill holes as per dwg

3-Deburr if necessary

=> m.k 10/05/10

20X

FB 10-5-19

21

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 10-5-19

# Work Order ID 58857

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Page 2

Item ID: D3953-17

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Start Date: 5/19/10 Start Qty: 18.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*Subtotal*

*x 20  
count*

130



Small Fab

Small Fab

Memo

1- OPEN HOLES AS PER DWG

2- DEBURR IF NECESSARY

0.00

0.00

*nl  
5*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

# Work Order ID 58857

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Page 3

Item ID: D3953-17

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Spacer

Stop



Start Date: 5/19/10 Start Qty: 18.00



Cust Item ID:

Required Date: 5/26/10 Req'd Qty: 18.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: 107

0.00



Packaging

Memo

0.00

Packaging

10/12/20 (20)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/20

10/05/20

# Picklist Print

May 19, 2010 10:28:47 AM

Page 1

Work Order ID: 58857

Parent Item: D3953-17

Parent Item Name: Gas Spring Spacer

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Start Date: 5/19/10

Required Date: 5/26/10

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304B0.375X03.000		Purchased	No			100	f	3.4000	0.03125	7		



M304 SS bar .375 x 3.00



B10-5-19

Location

Loc Qty

Loc Code

MAT53

3.4

113679

3.4

113679

(21)

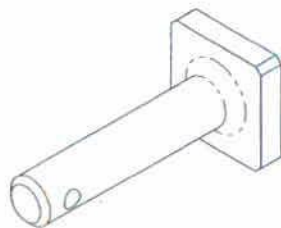


58857

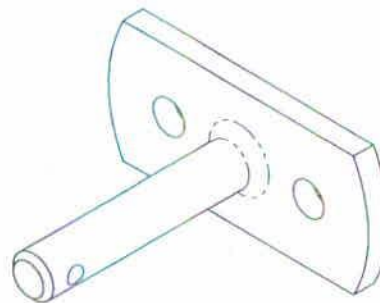
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ	



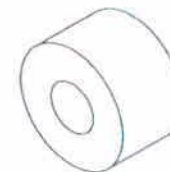
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



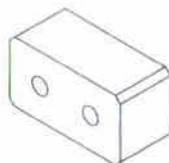
**D3953-7 GAS SPRING SPACER**



**D3953-9 GAS SPRING WASHER**



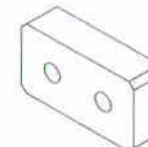
**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**  
(FULL LID)



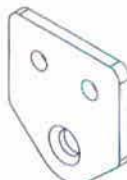
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)

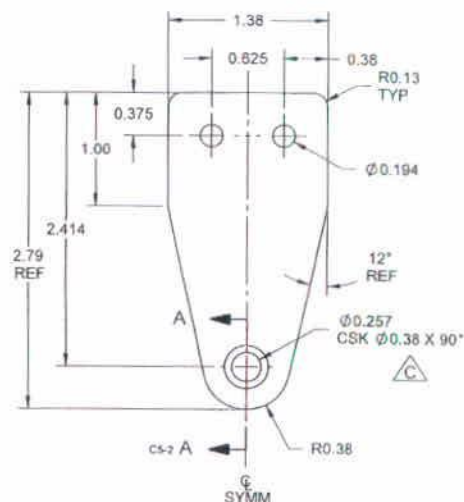


**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

**RELEASED**  
2010-02-25

C	PARTS -19 & -21 ADDED (SHT 1&4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C5-4). & SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B3-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS		JPH	10.01.29
B	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY		AJS	09.11.11
A	NEW ISSUE		AJS	09.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH			
CHECKED	[Signature]		DRAWING NO.	REV. C
MFG. APPR.	[Signature]		D3953	SHEET 1 OF 4
APPROVED	[Signature]		TITLE	SCALE
DE APPR.	[Signature]		GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES NOT COVERED BY THE ORIGINAL PURCHASE ORDER CONTROLLED DOCUMENT FROM DART AEROSPACE LTD	

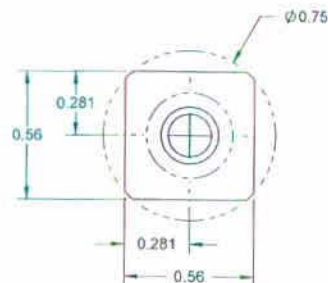
*Handwritten:* 55857



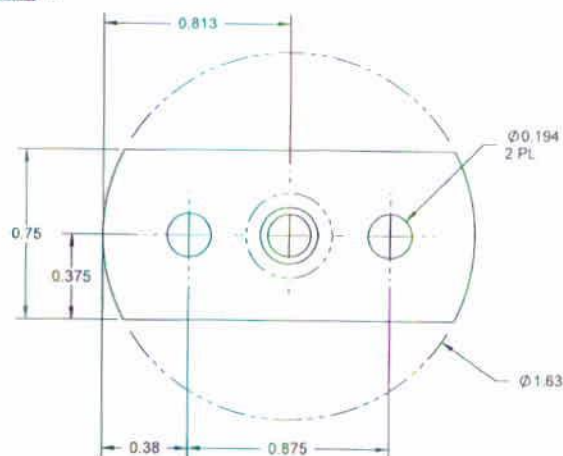
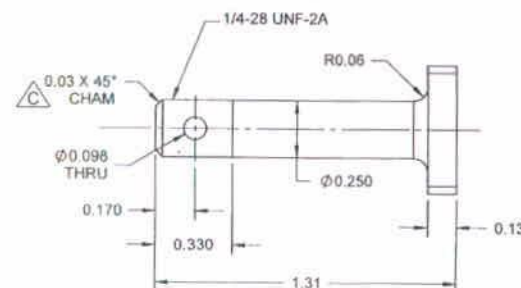
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



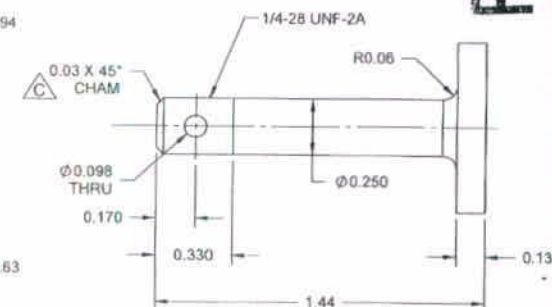
**SECTION A-A** CP-2



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



**NOTES**

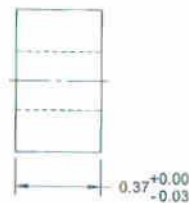
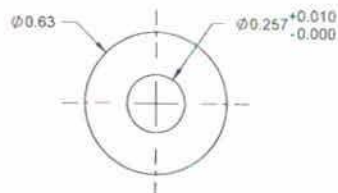
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3 & -5: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B OR AISI 304/316 STAINLESS STEEL ROD REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.11 lbs  
-3: 0.03 lbs  
-5: 0.06 lbs

*Handwritten signature and date: 50097*

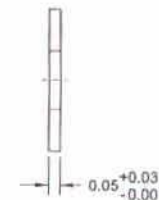
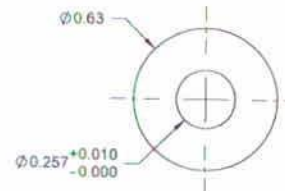
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR.	<i>[Signature]</i>	D3953	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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**RELEASED**  
R 2010-07-26

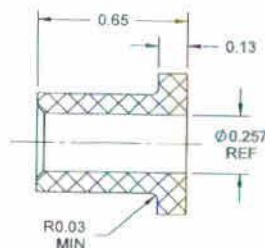
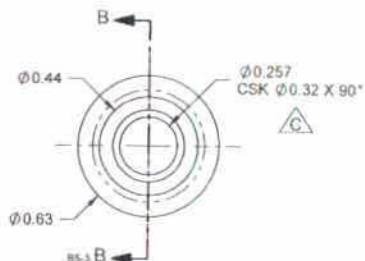




**D3953-7 GAS SPRING SPACER**

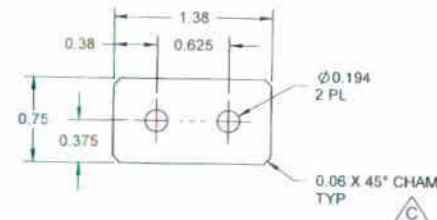


**D3953-9 GAS SPRING WASHER**



**SECTION B-B**

**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**

**NOTES:**

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

**RELEASED**  
2010-02-26

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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*info 58057*





RELEASED  
2010-02-26

- NOTES:
- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
  - 17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT -15: 0.08 lbs  
-17: 0.10 lbs  
-19: 0.07 lbs  
-21: 0.06 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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